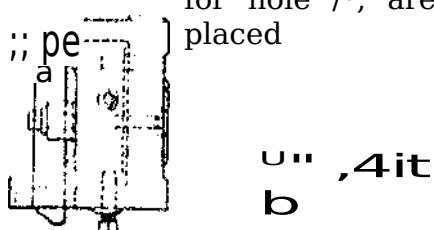


one way or another, and thus cause the bushings to stand at an angle with the work, producing faulty results. In order to avoid this objectionable feature, a further improvement on the jig, indicated in Fig. 9, is proposed. In the jig body, the locating points and the set-screws which hold the work against the locating pins are placed so that they will not interfere with two straps G, which are provided with elongated slots, and hold the work securely in place, also sustaining the thrust from the cutting tools. These straps should be heavily designed, in order to be able to take the thrust of the multiple-spindle drill, because in this case all the bushings, except the one for hole /*, are

Kfr 9» M i[®]

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in the bottom of the jig body. The Uruf is madt* narrower and is not as heavy as the one shown in Fig, H, hmwst* it tlm*s not, in this case, take any thrust when drilling, ami simply serves the purpose of holding the bushing for holt* H. Tltr leaves ami loose bushing plates for jigs of this kind art* gtwrally mittir of machine steel, but for larger sized jigs they may br made of i:ust Iron, The leaf in Fig. 9 is simply held down by the thumb-screw IL

If the holeJ? comes near to ontr wall of ifir Jig, it may not be necessary to have a leaf, but the jig nwy tie with a projecting lug D, as shown in Fig, to, tlir jig luting of the same type as the one in «j, Titr projecting